


Date: Tuesday, 04/07/2006 2:35:26 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 27811	
Estimate Number : 12423	
P.O. Number : N/A	Part Number : D35051
This Issue : 04/07/2006 S.O. No. : N/A	Drawing Number : D3505 PRELIMINARY
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : PREL
Previous Run :	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 04/08/2006 Qty: 2 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 06-05-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963125	105 I Beam Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

105 I Beam Extrusion 125" Long

Batch: 27775

BE 06-06-07 (2)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to Length as per Dwg D3505

BE 06-06-07 (2)

2-Drill Pilot Holes using DT8869 Drill Jig

BE 06-06-07 (2)

3-Open pilots to 1.000" as per Dwg D3505

BE 06-06-07 (2)

4-Deburr

BE 06-06-07 (2)

Tools: Pilot

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PH 06/07/06 (2)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PH 06-07-13 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 26/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 04/07/2006 2:35:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 27811

Part Number: D35051

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-7-13

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part # and Batch then Stock in Landing Gear

Location: 46

DP 6-7-13

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.14

Job Completion



U 06.07.14

Date,
Return to PH after completion

06/07/11

RL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

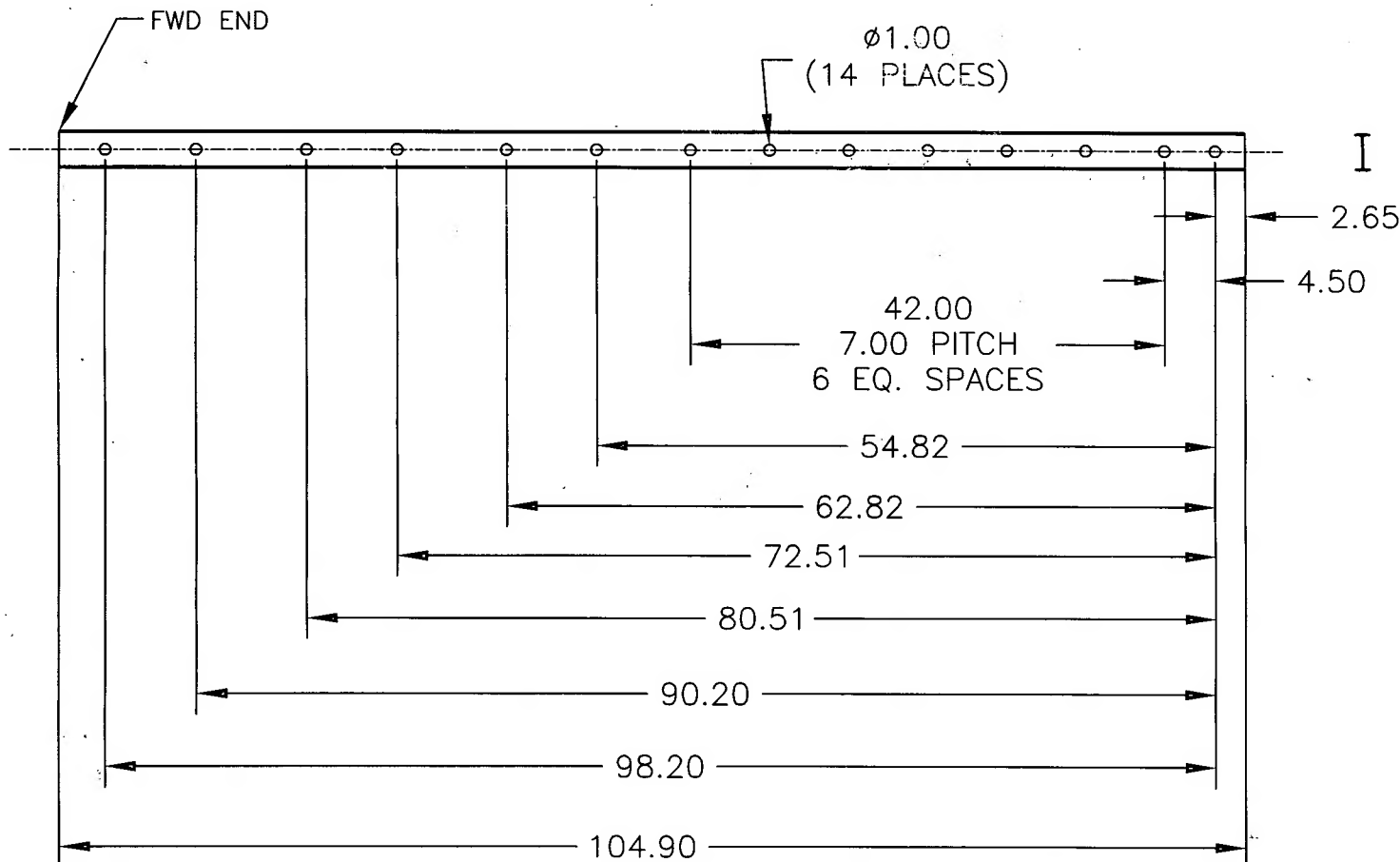
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	06.04.21	DRAWING NO.	D3505	REV. A
		TITLE	WEB	SHEET 1 OF 1
A	06.04.21	NEW ISSUE		SCALE 1:15



D3505-1 WEB

D3505-1 WEB

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

$$\begin{array}{r} 1.656 \\ 3.312 \\ \hline \end{array}$$

$$\begin{array}{r} 1.6247 \\ 2.496 \\ \hline \end{array}$$

